

Work Order ID 60566

Wednesday, July 14, 2010 9:18:54 AM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 7/14/2010 Start Qty: 8.00

Required Date: 7/22/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-7-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev F3

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

0.00

0.00

8/10/09/29

10/07/29 BG 10/07/29 (6)

160



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

10/7/29 6x50

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

8/10/09/29

(76)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D350-578-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 7/14/2010 Start Qty: 8.00

Required Date: 7/22/2010 Req'd Qty: 8.00

Cust Item ID:



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Packaging	Packaging	0.00	REQ A			10/17/09 (60) SF			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: <u> </u>								
190  QC	QC21- Final Inspection - Work Order Release	0.00							10/07/30 SF
Quality Control	Memo	0.00							

PR10-7-28 (6)

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:18:58 AM

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Work Order ID: 60566

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A Bolt		Purchased	No			160	Each	656.0000	12	9672		10/7/29	\$
<div> <div>Location</div> <div>ST359</div> <div>112314</div> <div>Loc Qty</div> <div>656</div> <div>656</div> <div>Loc Code</div> </div>													
D2182B Rubber Cushion		Manufactured	No			160	f	254.3952	2.5	75		10/7/29	\$
<div> <div>Location</div> <div>ST402A</div> <div>30872</div> <div>Loc Qty</div> <div>9.67</div> <div>9.67</div> <div>Loc Code</div> </div>													
<div> <div>Location</div> <div>ST410</div> <div>52649</div> <div>Loc Qty</div> <div>244.7252</div> <div>244.7252</div> <div>Loc Code</div> </div>													
Cut qty 6 at 5.00" long D2274 Radius Block		Manufactured	No			160	Each	355.0000	12	9672		10/7/29	\$
<div> <div>Location</div> <div>ST010</div> <div>57912</div> <div>Loc Qty</div> <div>355</div> <div>135</div> <div>Loc Code</div> </div>													
<div> <div>Location</div> <div>59108</div> <div>Loc Qty</div> <div>220</div> <div>Loc Code</div> </div>													
D2432 206 (24") Bearpaw		Manufactured	No			160	Each	0.0000	2	1612		10/7/29	\$

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 60566

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 8.00 6

Required Qty: 8.00

D2438

Manufactured No

160

Each

64.0000

6



Clamp



48 36
10/2/09

Handwritten signature

Location

Loc Qty

Loc Code

ST456

64

59123

64

D2529

Manufactured No

160

Each

338.0000

12



Washer



36
9672
10/2/09

Handwritten signature

Location

Loc Qty

Loc Code

ST017

338

58568

338

MS21042L4

Purchased No

160

Each

4,191.000

12



Nut



72
9672
10/2/09

Handwritten signature

Location

Loc Qty

Loc Code

ST300

4191

113422

68

114523

28

114718

95

114784

2000

115108

2000

72

Wednesday, July 14, 2010 9:18:58 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, July 14, 2010 9:18:58 AM

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Work Order ID: 60566

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

3,783.000

24



Washer



192/44
10/7/29 SP (ex)

Location

Loc Qty

Loc Code

ST297

3687

115000

3687

ST298

96

10096

10

114576

68

114883

18

144

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO

WITH

WORK ORDER

NO. C0564



DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. F
SHEET 1 OF 2

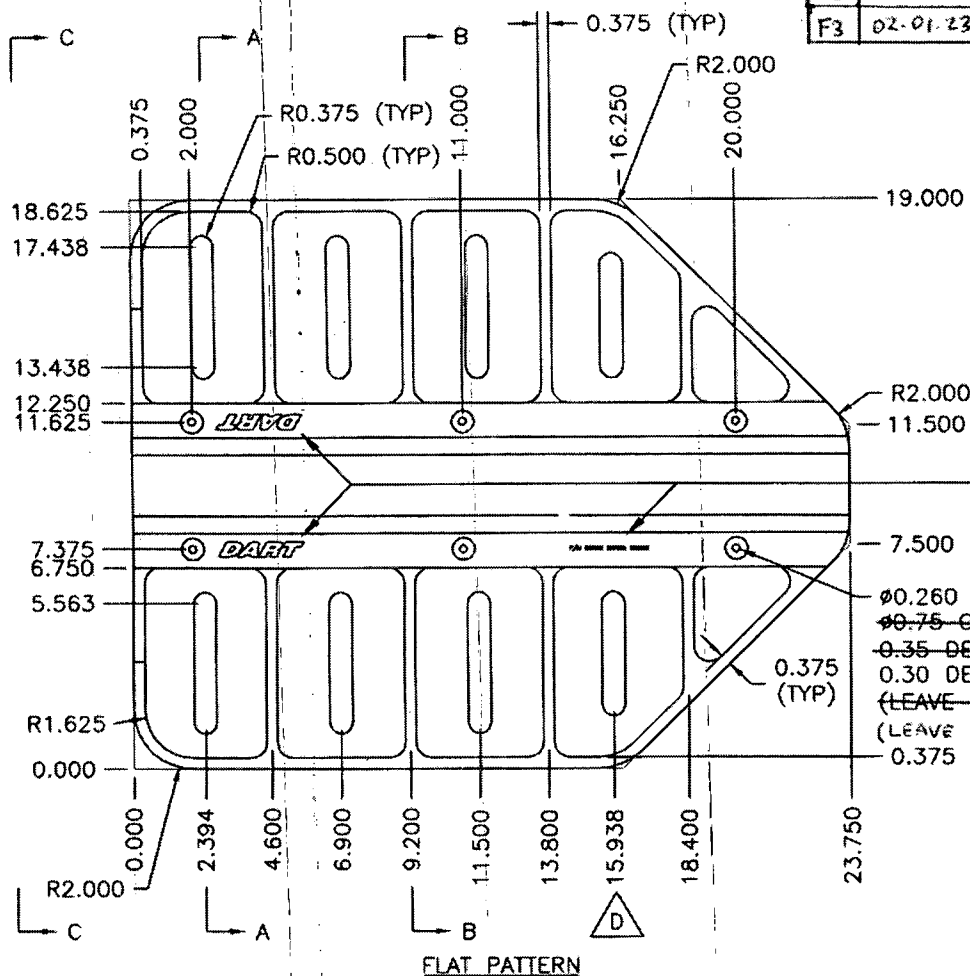
DESIGN	DRAWN BY	DRAWING NO.	TITLE	SCALE
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CHECKED	APPROVED			
DATE				
98.05.12				

RELEASED
43.06.17 KE

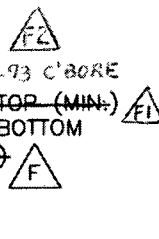
880-7-14

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP)
Ø0.75 C'BORE Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)



EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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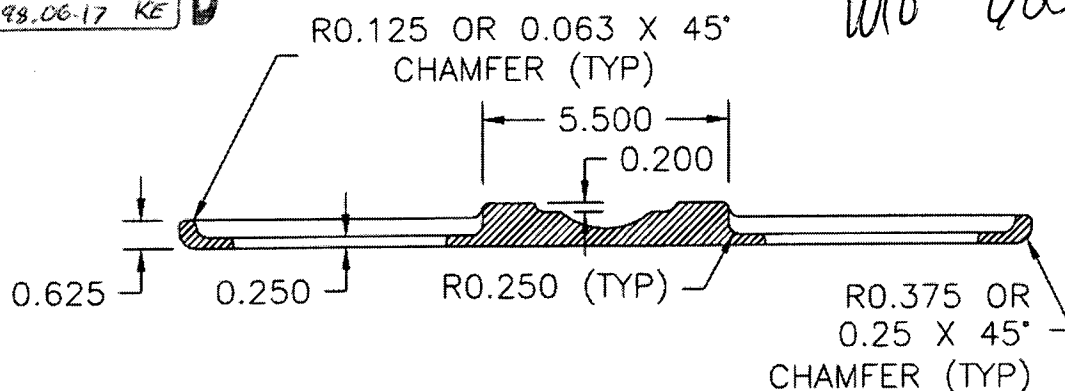
NOTE: Date & initial all entries



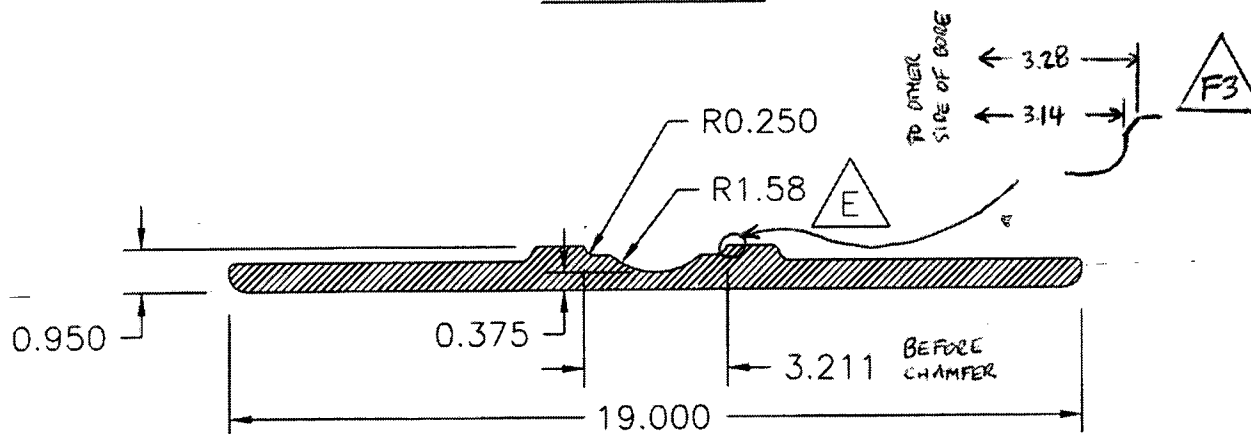
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE

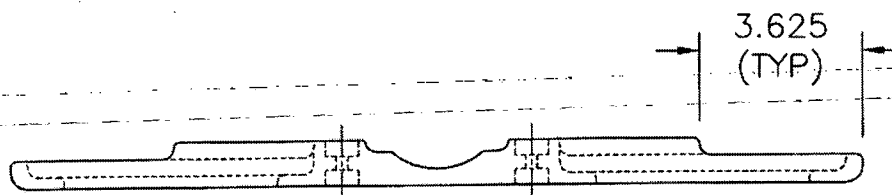
Wto 60564



SECTION A-A



SECTION B-B



SECTION C-C

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

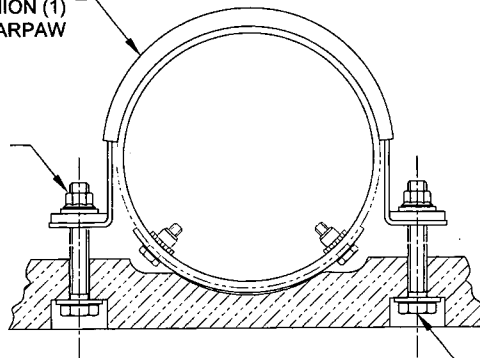
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ENCE ONLY

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



REFERENCE ONLY

ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 - Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F
Date: 08.08.28